

Work Order ID 72707

Tuesday, August 09, 2011 9:55:35 AM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 8/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: Date: 11-08-9

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3909	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg Trim rivet to 1.185" long								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 11/08/09 (2)

EP 11/08/10 (2)

S. Wosko

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72707

Tuesday, August 09, 2011 9:55:35 AM



Page 2

Item ID:	D3909-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Lug Assembly, Fwd					
Start Date:	8/9/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	8/10/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>471</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/95
2

CK 11/08/10

11-08-10
2

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 09, 2011 9:55:43 AM

Page 1

Work Order ID: 72707

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 8/9/2011





Required Date: 8/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	18.0000	1	2		8/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				18					
					70920			18					
D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	12.0000	2	4		8/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				12					
					71002			12					
D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	11.0000	1	2		8/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST081				11					
					57819			1					
					65628			10					
D3909-5  Eyebolt Stud		Manufactured	No			100	Each	7.0000	1	2		8/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				7					
					65629			7					

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Page 2

Work Order ID: 72707

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 8/9/2011

Required Date: 8/10/2011

Start Qty: 2.00

Required Qty: 2.00

D3910-1 Manufactured No

100 Each

20.0000

2

4



Crosstube Lug

Location

Loc Qty

Loc Code

ENG

18

70160

18

st507

2

68263

2



EP 11/08/09

4

D3917-1 Manufactured No

100 Each

3.0000

2

4



Washer

Location

Loc Qty

Loc Code

ST092

3

66322

3



EP 11/08/09

372710 (1X)

3

AN3C12A Purchased No

100 Each

100.0000

4

8



Bolts

Location

Loc Qty

Loc Code

ST351

100

117514

4

118112

5

118422

49

118451

42



EP 11/08/09

8

AN3C13 Purchased No

100 Each

47.0000

1

2



Bolt

Location

Loc Qty

Loc Code

ST351

47

114714

47



EP 11/08/09

2

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Shop Packet Print

Page 2

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Page 3

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Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 8/9/2011

Required Date: 8/10/2011

Start Qty: 2.00

Required Qty: 2.00

MS17984-C413

Purchased

No

100

Each

5.0000

1



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST297

1

118546

1

ST315

4

114340

1

117557

3

MS20615-4M20

Purchased

No

100

Each

46.0000

3



RIVET

Location

Loc Qty

Loc Code

GA

46

117071

46

AN310C3

Purchased

No

100

Each

45.0000

1



Castellated Nut

Location

Loc Qty

Loc Code

ST349

45

114714

45

MS21043-3

Purchased

No

100

Each

670.0000

4



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

598

112314

6

118077

592

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Shop Packet Print

Page 3

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Tuesday, August 09, 2011 9:55:44 AM

Page 4

Work Order ID: 72707

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 8/9/2011

Required Date: 8/10/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-151

Purchased

No

100

Each

432.0000

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

432

17566

432

NAS1149C0332R

Purchased

No

100

Each

7,125.000

8



Washer

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

7118

116304

55

117460

62

117887

199

118078

2

118179

86

118306

1714

118354

5000

NAS1149C0363R

Purchased

No

100

Each

4,221.000

2



Washer

Location

Loc Qty

Loc Code

ST297

4221

114742

4221

2
8/11/08/09

2
16
8/11/08/09

4
8/11/08/09

4

Tuesday, August 09, 2011 9:55:44 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

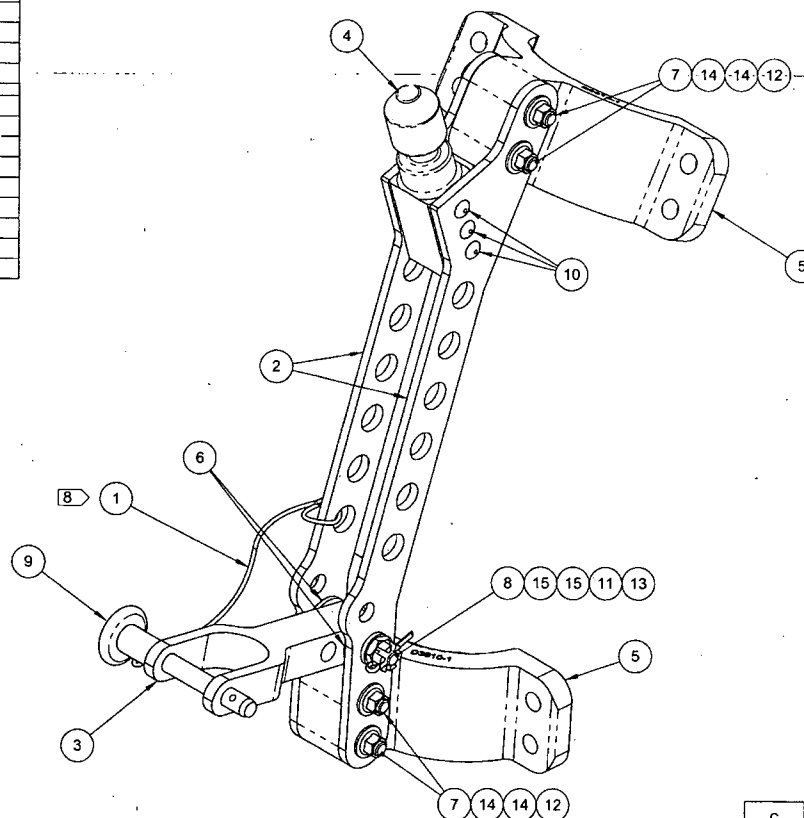
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 1.81 lbs

8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72707

R11-08-7

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041/5)	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 WAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 19. SHI-3: D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.04 WEIGHT REVISED	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

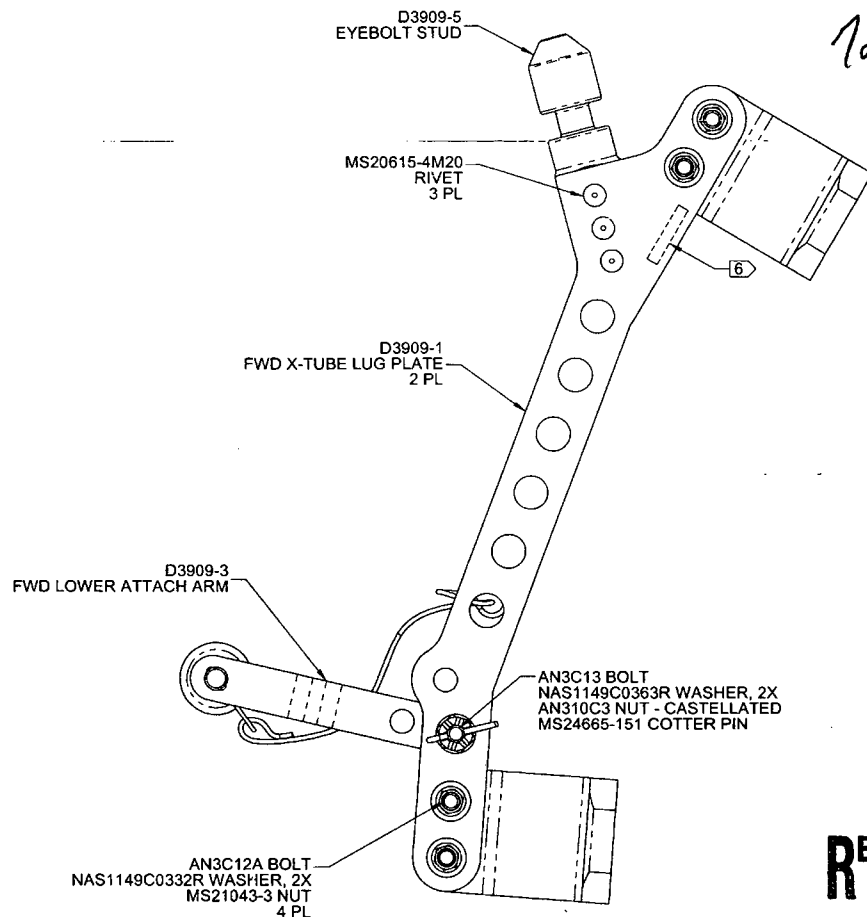
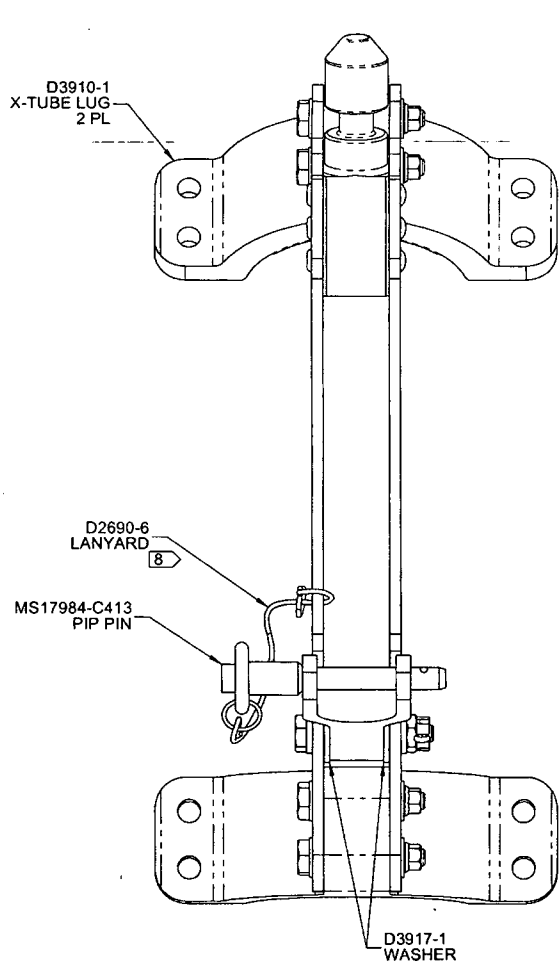
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-041 FWD X-TUBE LUG ASSY

72707

RELEASED
2010-08-11

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 2 OF 5
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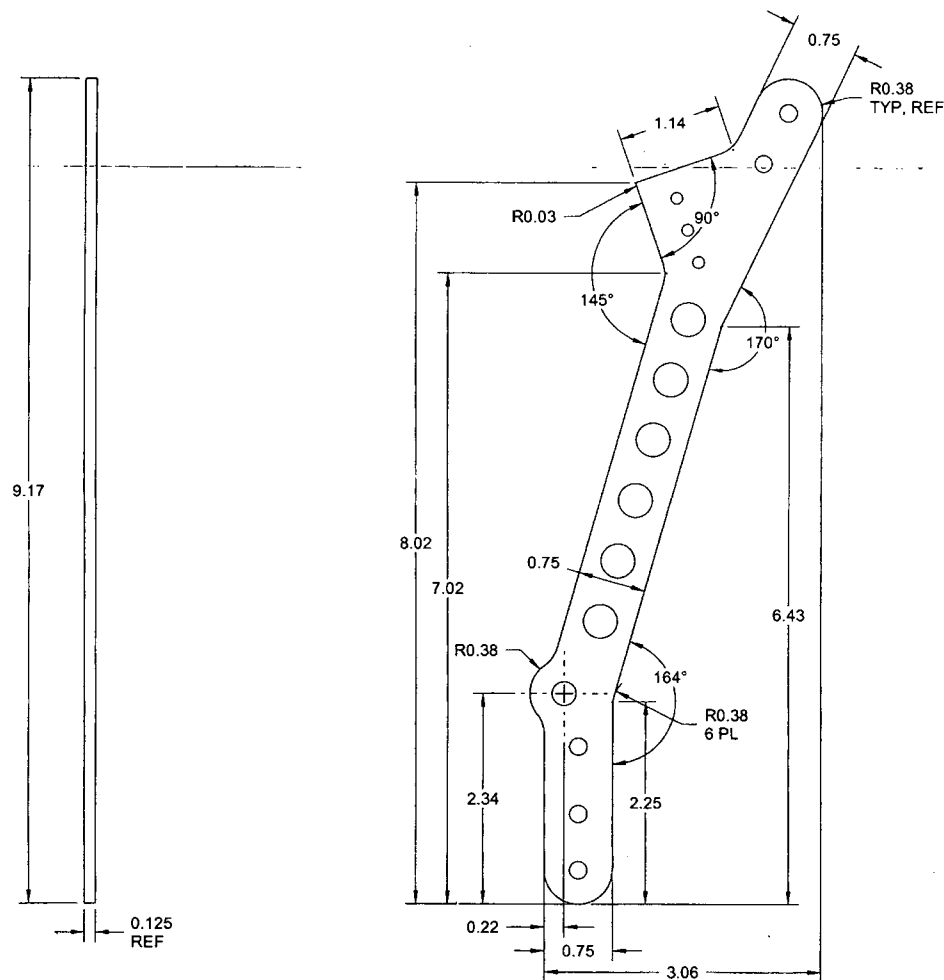
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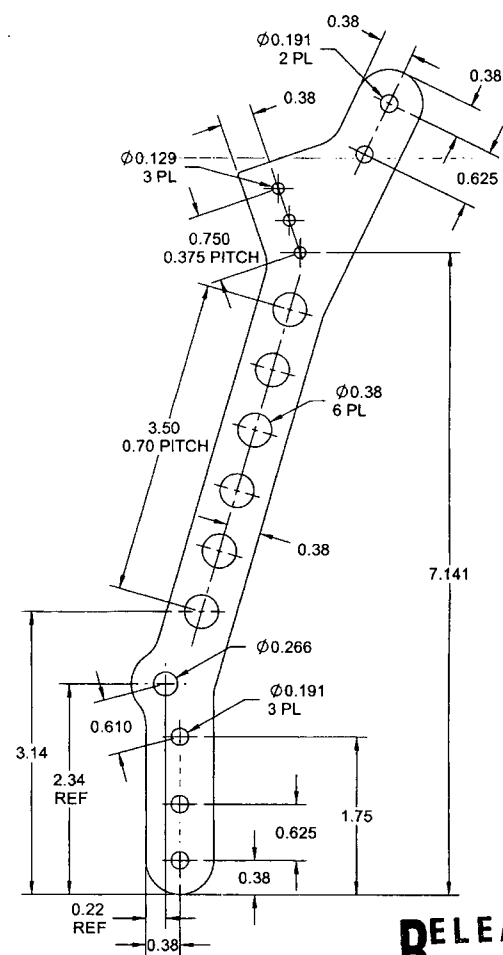
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NOTE: Date & initial all entries

72207



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

RELEASED
2010-08-01

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 3 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD.X-TUBE LUG ASSY. _____ NTS	
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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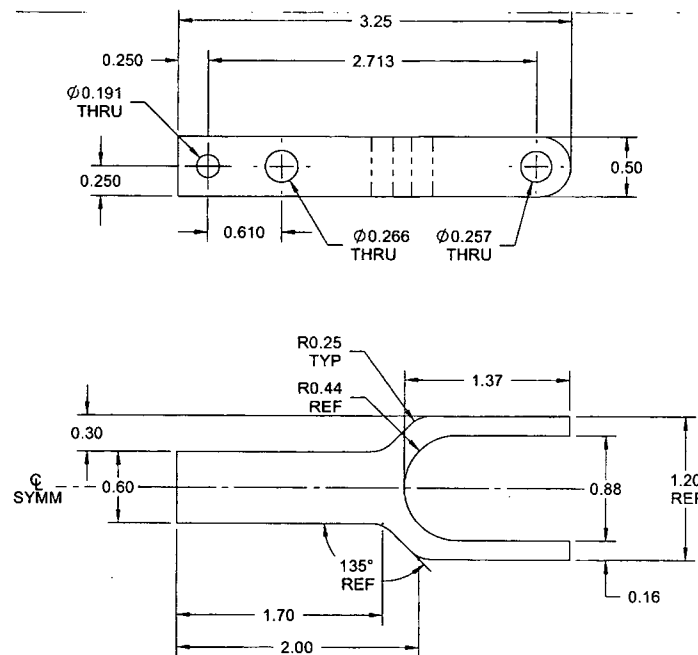
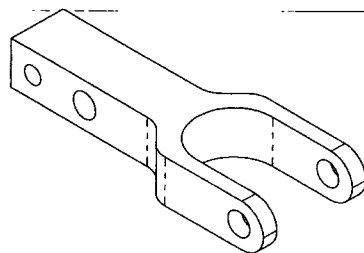
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

72101



D3909-3 FWD LOWER ATTACH ARM

RELEASED
2010-08-06

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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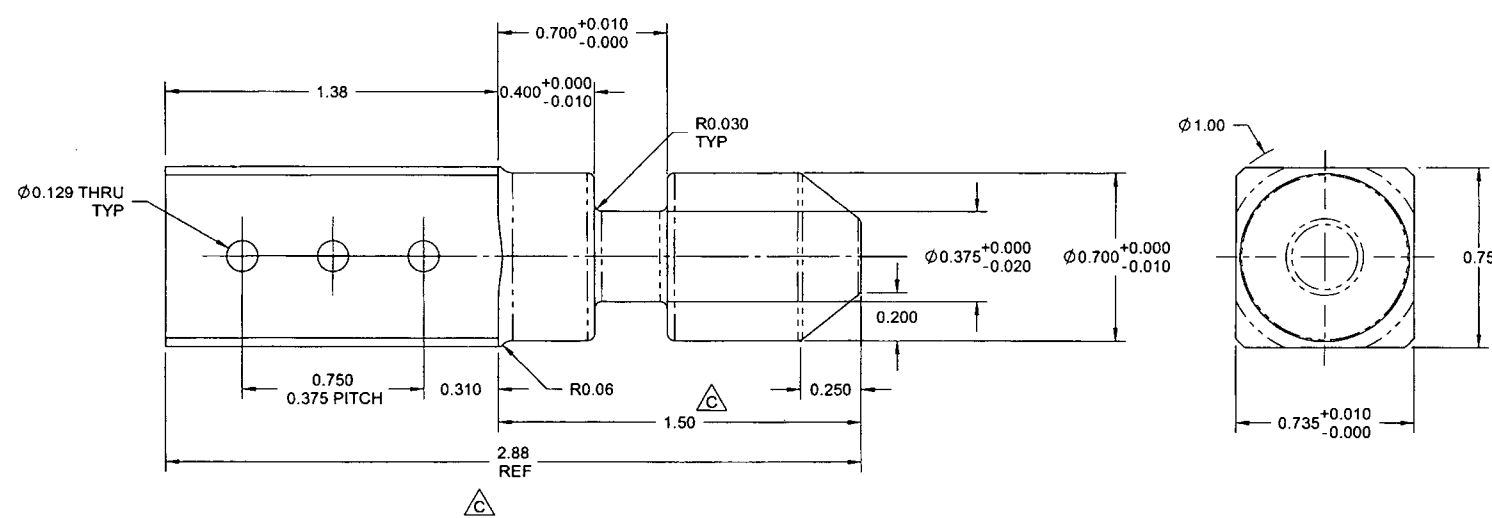
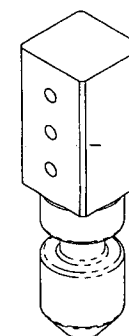
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72707



D3909-5 EYEBOLT STUD

RELEASED
2010-08-04

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 5 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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